

Date: Thursday, 04/09/2008 9:01:42 AM  
 User: Julie Lecocq

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: BRACKET	
Job Number	: 41795		Part Number	: D32941	
Estimate Number	: 11181		Drawing Number	: D3294 PROTO E	
P.O. Number	:		Project Number	: N/A	
This Issue	: 04/09/2008	S.O. No. :	Drawing Revision	: PROTO E	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type : R & D SM/MED FAB	Due Date	: 11/09/2008 Qty: 2 um: Each	
Previous Run	: 40544				
Written By	:				
Checked & Approved By	: JUL 08.9.04				
Comment	: Est A 04.08.24 New issue KJ/JLM Est Rev:B Now On Waterjet 07-03-26 JLM Est Rev:C 08-07-16 Redesign part DD verified by:EC				

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S080	2024-T3 .080 sheet
		<b>Comment:</b> Qty.: 2.1072 sf(s)/Unit Total : 25.2869 sf(s) Material: 2024-T3 (QQ-A-250/4) 0.080" thick (M2024T3S.080) Identify for D3294-1 Batch: 109424 B 8-10-21
2.0	WATER JET	FLOW WATER JET
		<b>Comment:</b> FLOW WATER JET 1-Cut as per Dwg D3294 Dwg Rev: A B 8-10-21 Prog Rev: _____
		2-Deburr if necessary B 8-10-21
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		B 8-10-21
		<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		S 08/10/22
		Y2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 9:01:42 AM  
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Drawing Name: BRACKET

Job Number: 41795

Part Number: D32941

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

NC BRAKE

Done at step #22

6.0 BRAKE NC



Comment: NC BRAKE

Form as per Dwg D3294

28 08/10/27

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

So 08/10/27 X2

(2X)

9.0 POWDER COATING

POWDER COATING



M 10 S 642

(2X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

7:20

START TIME:

320 OF

OVEN TEMPERATURE:

7:30

FINISH TIME:

m-f 08/10/28

10.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

Fd 08/10/31

(2)

11.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPD . 41359

SS 08/10/31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 9:01:42 AM  
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Drawing Name: BRACKET

Job Number: 41795

Part Number: D32941

Job Number:



Seq. #:	Machine Or Operation:	Description :
12.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE



08/11/03 JF

Job Completion



MF 08-10-31

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	41795
Description: Bracket	Part Number:	D3294-1
Inspection Dwg: D3294	Rev: A1	Page 1 of 1

# FIRST ARTICLE INSPECTION CHECKLIST

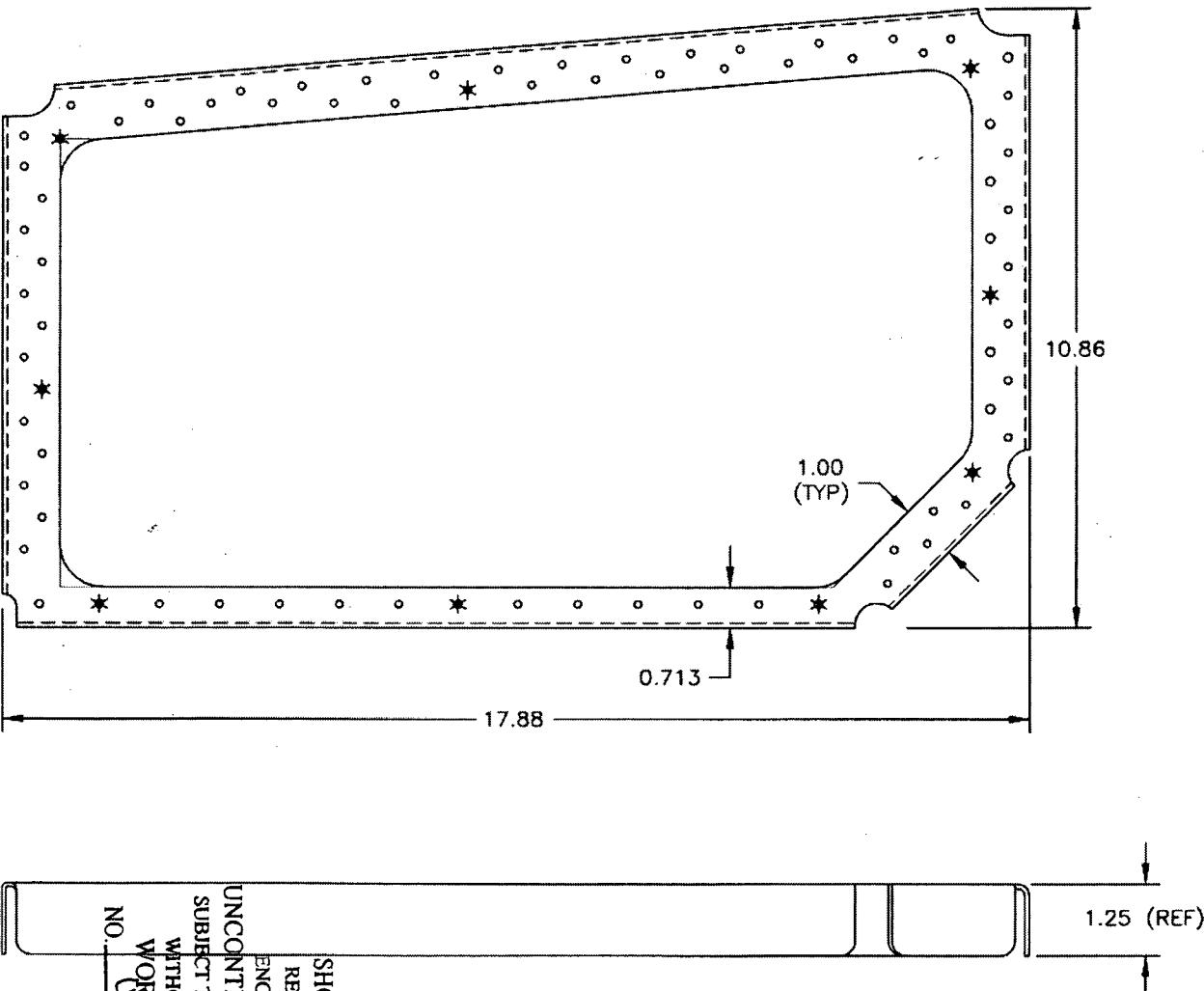
## X First Article      Prototype

Measured by:	<u>B</u>	Audited by:	<u>C</u>	Prototype Approval:	N/A
Date:	8/10/21	Date:	8/10/22	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	

D3294-1 BRACKET

- 1) MACHINE PER DRAWING FILE "D3294-A2.DWG"
- 2) CHECK PER TEMPLATE D3294-1T1
- 3) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.080 THICK (REF. DART SPEC M2024T3S.080)
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
- 5) USE MINIMUM BEND RADIUS OF 0.188"
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. Q1P

RELEASED  
04.07.12

**DART**



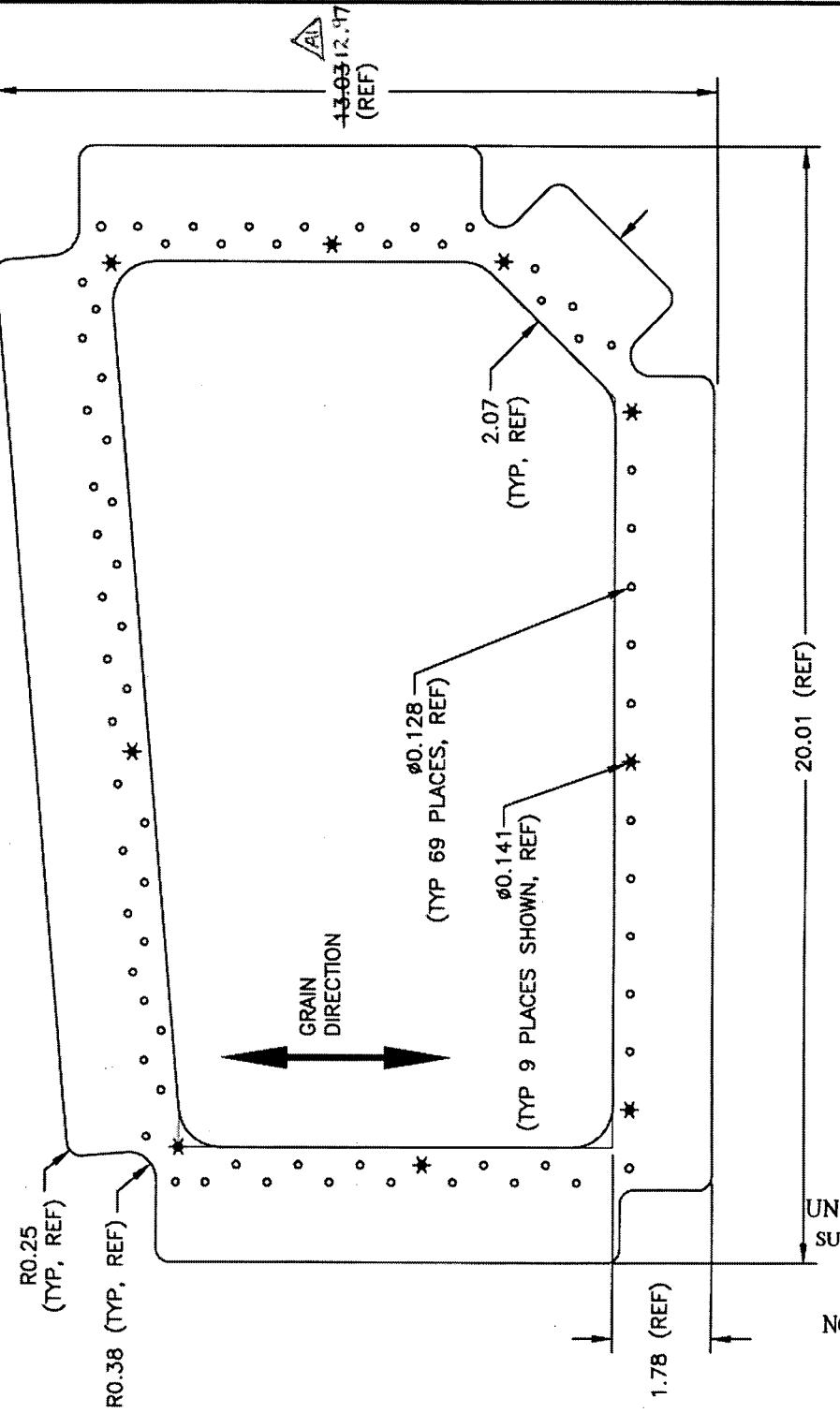
DESIGN	DRAWN BY	DART AEROSPACE LTD		
CHECKED	APPROVED	DRAWING NO.	REV. A	SCALE
<i>[Signature]</i>	<i>[Signature]</i>	D3294		SHEET 1 OF 2
DATE 04.06.28		TITLE BRACKET		1:3
A A1	<i>[Signature]</i> 05.06.13	NEW ISSUE		
		12.57 WAS 13.03, AS MANUFACTURED		

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE	04.06.28	TITLE	SCALE

SHEET 2 OF 2

1:3

**D3294-1 FLAT PATTERN****RELEASED**  
04.07.12 *A*

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RETURN TO  
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WORK ORDER  
NO. 4C195

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